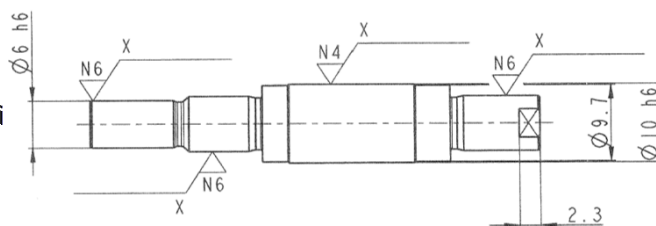


Eccentric shaft Ø7 Ø10 Ø7

A20-010-200

The excenter is preground in spiral plunging with the same CBN wheel as for D1 and D2. An additional wheel for finishing the excenter is used (CBN or ev. vitrified). A dressing cycle can be integrated as well as a probing cycle, if necessary.



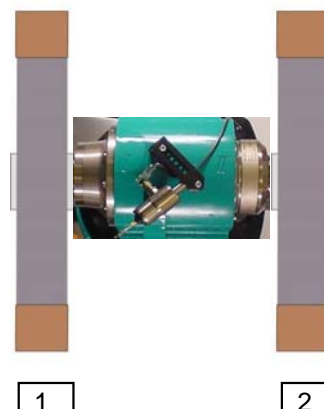
1. Cycletime for Production

Workpiece: Ø7 H6 Ø10 B4 Ø7 H6 Material HSS						
Operations						
Exc. Pregr.						
Cyl D1 fin.						
Cyl D2 fin.						
Exc. Fin.						
Probe D						
Load						
Feed [mm/Min]	2000	3000	3000	3000	2000	9000
Power [kW]	2	2	3	2		1
Cutting speed [m/s]	38	38	38	38		38
Used wheels						
Grinding time [s]	50	30	30	31	24	20
Total cycle time	3 Min 4					

The cycle times are indicative. Material to be ground, grinding wheels, coolants can influence the cycle times considerably.

2. Used Grinding Wheels

1	1A1 Ø250 CBN125 B20
2	1A1 Ø250 C80-120 B20



3. Machine and Software Requirements

Machines: 5 axes CNC grinders : GEMINI DMR

Control: Fanuc 31i

Accessories: STL6056, Dress, A-Rapid

Responsible engineer: OP. 20.11.12

Coolant: Synthetic Oil, pressure 6 bar

Software: Quinto 5

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